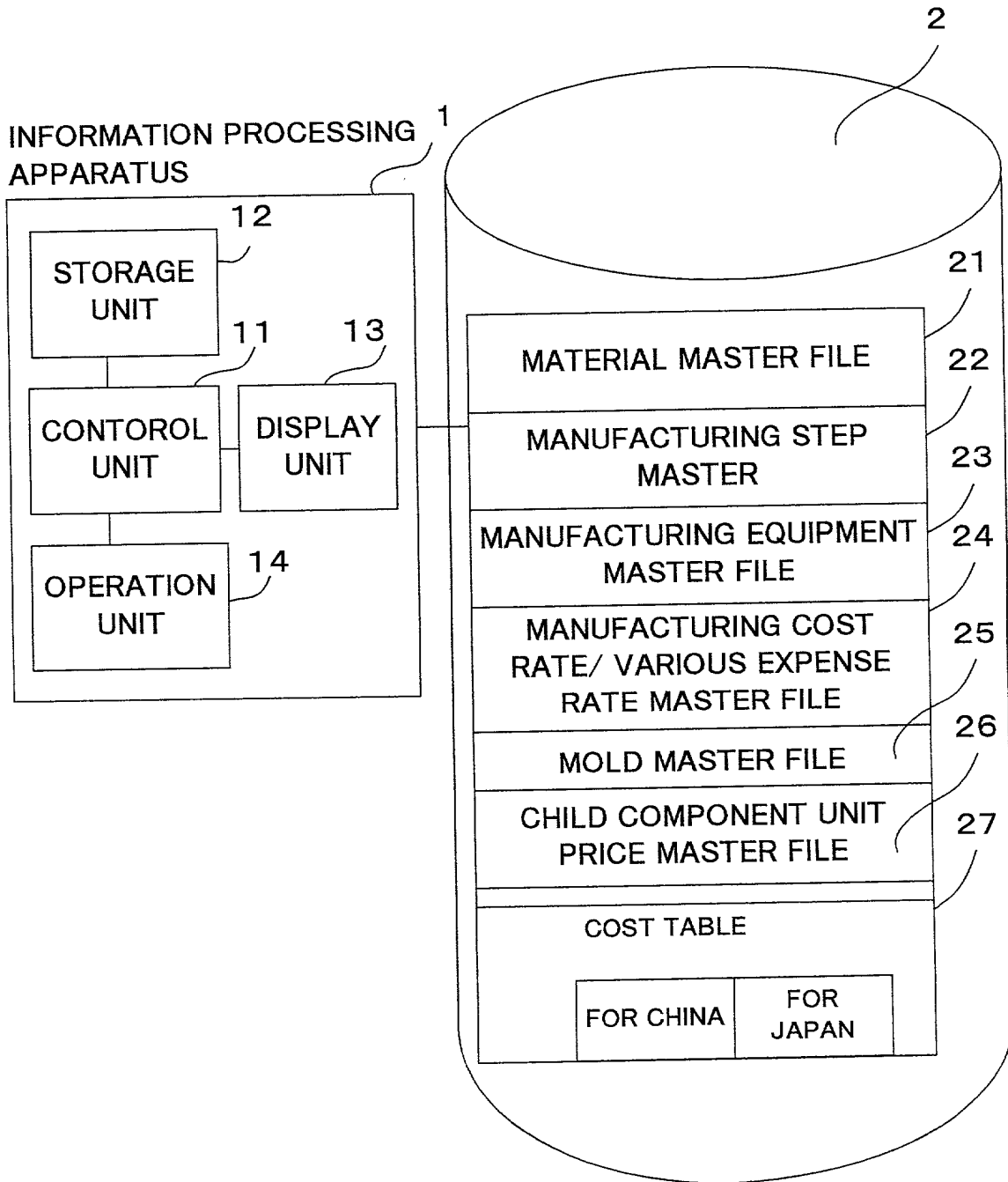


1/20  
FIG.1



# 2/20

## FIG.2A

MATERIAL COST TABLE

MATERIAL NAME	BOARD THICKNESS	UNIT PRICE	DETAILS OF EXPENSE	OTHERS
SECC-C-E16/E16 (ZINC STEEL PLATE)	0.40	95.00	PLATE EXPENSE91.22 MANAGEMENT EXPENSE 3.78	.....
	0.50	95.00	.....	.....
	0.60	94.00	.....	.....
	.....	.....	.....	.....
AA1050P-H24	0.40	86.00	.....	.....
	.....	.....	.....	.....
.....	.....	.....	.....	.....

FIG. 2A

# 3/20 FIG.2B

MANUFACTURING EQUIPMENT COST TABLE

DEVICE NAME	PREPARAT ION TIME	PROCESSING TIME	UNIT PRICE/ HOUR
PRESS 90t	0.1	$1.3 + 0.1 \times L \times W \times T$	.....
.....	.....	.....	.....
MILLING MACHINE	0.2	$1.0 + 0.9 \times L \times W \times T$	.....
.....	.....	.....	.....

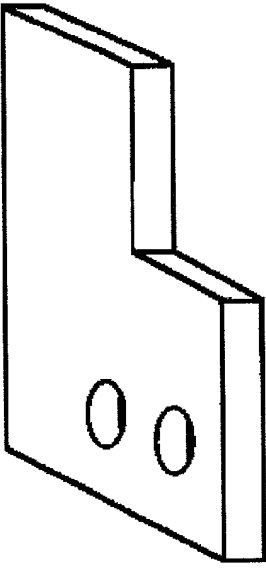
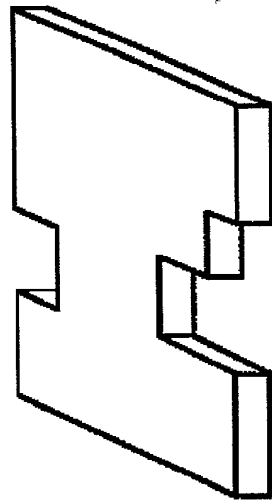
10029270-122801

4/20

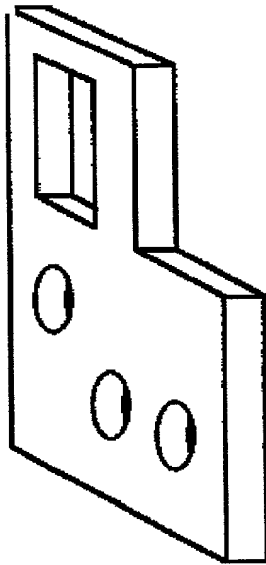
FIG.3

FORMING APPEARANCE PLUS PUNCHING

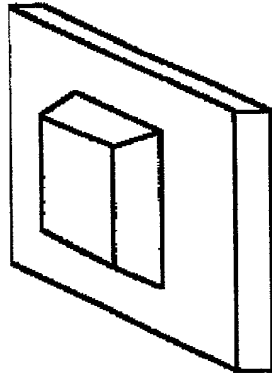
FORMING APPEARANCE



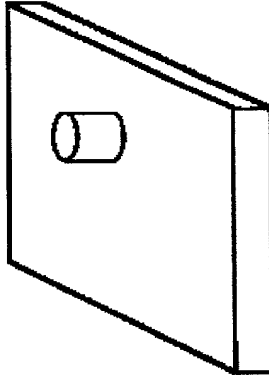
PUNCHING



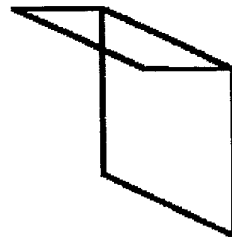
ONE TYPE OF EMBOSSING



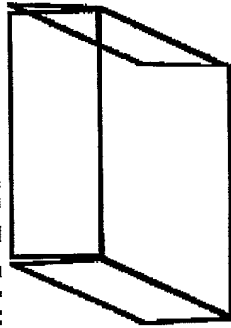
EMBOSSING



V-SHAPE BENDING

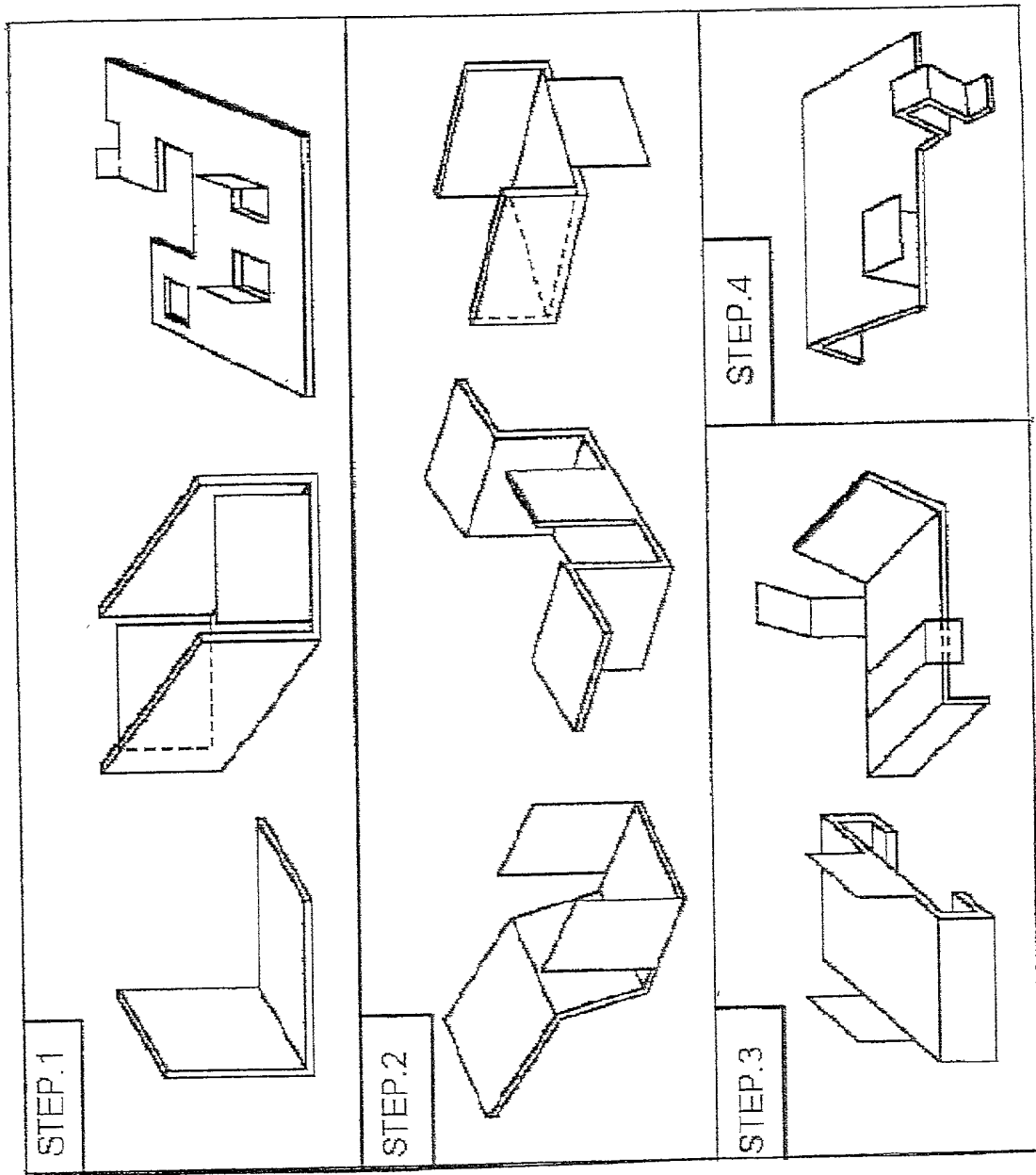


FORMING BOX SHAPE BY BENDING

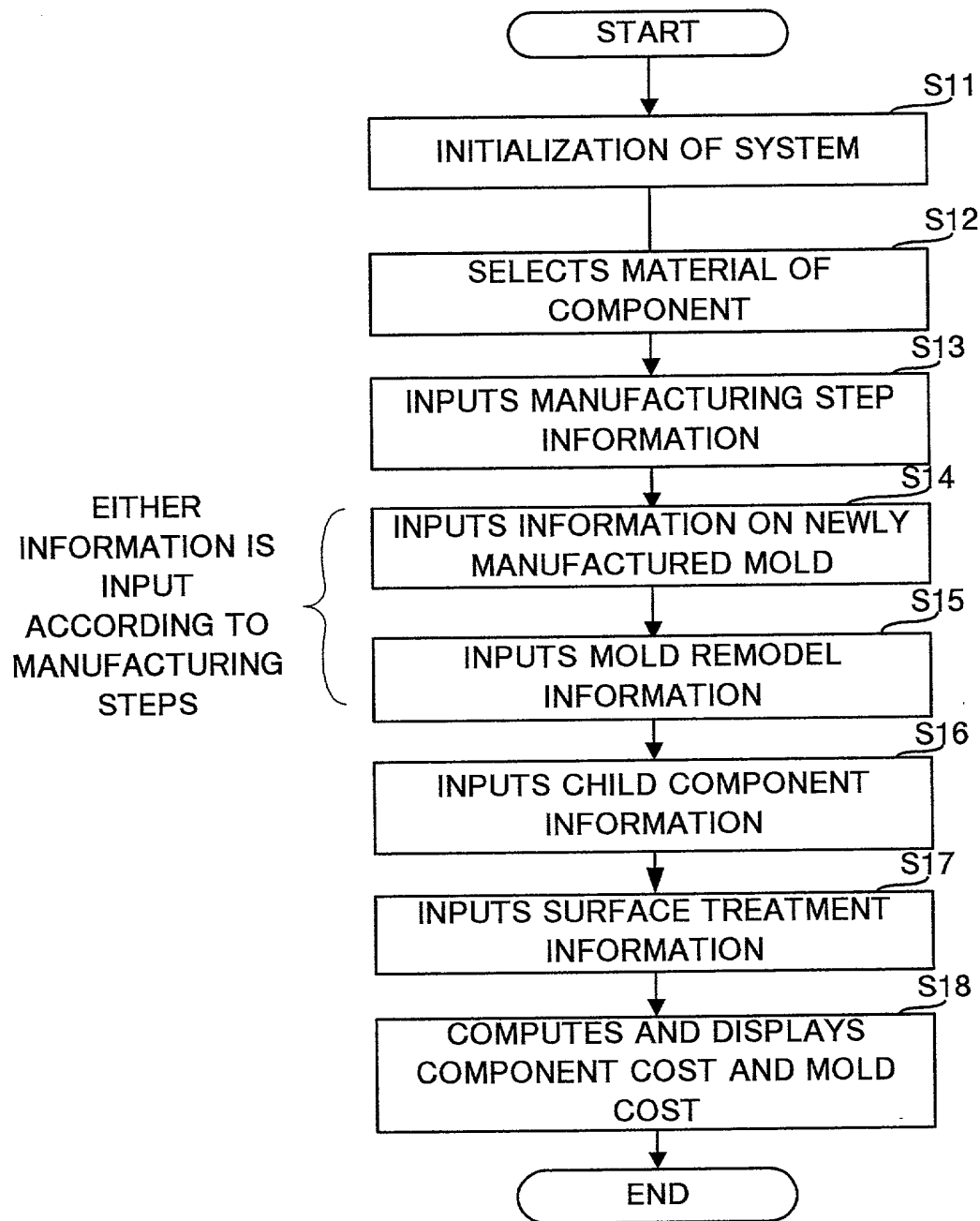


5/20

FIG.4



**FIG.5**



7/20

FIG. 6

PRESS

CODE NUMBER

SUFFIX

KIND

NAME OF COMPONENT

MENU

UNIT PRICE OF COMPONENT

YEN

MATERIAL EXPENSE

MANUFACTURING COST

OTHERS

YEN

(CHILD COMPONENT COST)

YEN

YEN

YEN

YEN

PRIMARY MANUFACTURING COST

SECONDARY MANUFACTURING COST

MANUFACTURING STEP INFORMATION

<MOLD COST DATA>

SUM TOTAL

YEN

COMPUTATION OF SUM TOTAL

NOT USE

TYPICAL MOLD

MASTER DIE SET TYPE MOLD

<BASIC DATA>

MONTHLY LOT

LOTS/MONTH

TOTAL LOT

LOTS

MATERIAL CODE

LIST

MATERIAL NAME

SPC SE

BOARD THICKNESS

mm

MATERIAL FORM

SECURE NUMBER

EXTEND WIDTH

mm

EXTEND LENGTH

mm

OUTER CIRCUM-FERENCE LENGTH

mm

<MANUFACTURING STEP INFORMATION>

COMPONENT HARD TO HANDLE

NO.	NAME OF MANUFACTURING STEP	DESIGNATED COST CENTER	MANUFACTURING COST	MOLD COST	REMODEL
1					
2					
3					
4					

LIST OF COMPONENTS FOR COST COMPUTATION

LIST OF MOLDS FOR COST COMPUTATION

READ

REGISTER

COMPUTE

ALL CLEAR

ALL CLEAR

COMPUTATION RESERVE

8/20

**FIG.7**

## LIST OF MATERIALS

## CLASSIFICATION BY MATERIAL NAME

A15654-986

A654-65908

**RESEARCH**

C654987-79

■ ■ ■ ■ ■ ■ ■

● ● ● ● ● ● ● ●

● ● ● ● ● ● ● ●

**謝 興 賢**

■ ■ ■ ■ ■ ■ ■ ■

■■■■■■■■■■

1000 2000 3000 4000 5000 6000 7000 8000 9000 10000

OK

## CLASSIFICATION BY MATERIAL CHARACTERISTIC

SPC

AL

BL



9/20  
FIG.8

LIST OF MATERIALS

CHARACTERISTIC OF MATERIAL

NO.	MATERIAL NAME	BOARD THICKNESS	UNIT PLACE	SPECIFIC GRAVITY
1	DOK-v-g-b-/W-16(ZINC PLATE)	0.4	95	7.886
2	DOK-v-g-b-/W-16(ZINC PLATE)	0.5	95	7.886
3	DOK-v-g-b-/W-16(ZINC PLATE)	0.6	90	7.886
4	DOK-v-g-b-/W-16(ZINC PLATE)	0.7	90	7.886
5	DOK-v-g-b-/W-16(ZINC PLATE)	0.8	85	7.886
6	DOK-v-g-b-/W-16(ZINC PLATE)	0.9	85	7.886
7	DOK-v-g-b-/W-16(ZINC PLATE)	1	80	7.886
8	DOK-v-g-b-/W-16(ZINC PLATE)	1.1	80	7.886
9	DOK-v-g-b-/W-16(ZINC PLATE)	1.2	75	7.886
10	DOK-v-g-b-/W-16(ZINC PLATE)	1.3	75	7.886
11	DOK-v-g-b-/W-16(ZINC PLATE)	1.4	70	7.886
12	DOK-v-g-b-/W-16(ZINC PLATE)	1.5	70	7.886

OK

CAN-CEL

10029270-122801

FIG. 9

BACK  
CANCEL  
HELP

INFORMATION ON COST OF NEW MOLD

EXTEND LENGTH  mm EXTEND WIDTH  mm EXTEND OUTER CIRCUMFERENCE LENGTH  mm

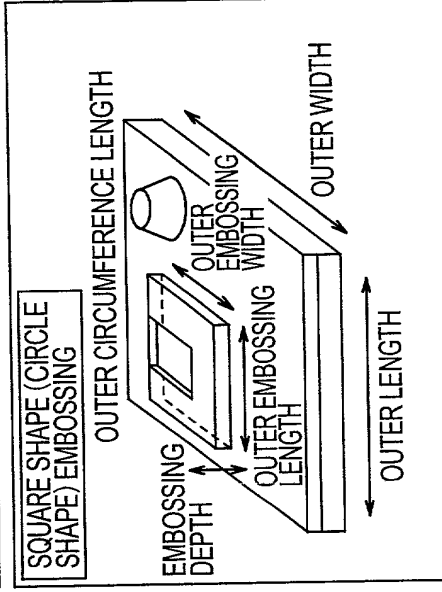
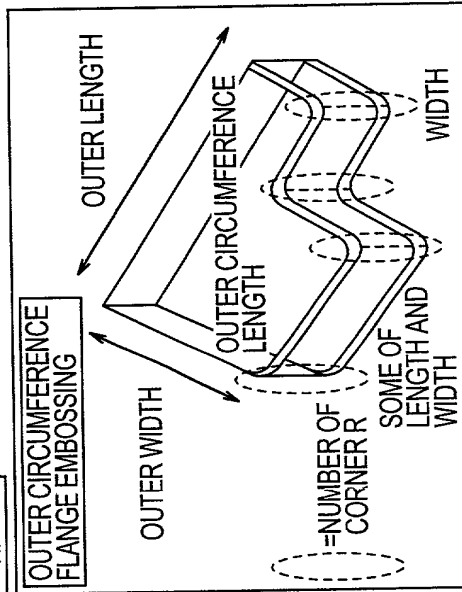
<DATA FOR BOX-SHAPE BENDING>

OUTER LENGTH  mm OUTER WIDTH  mm OUTER CIRCUMFERENCE LENGTH  mm  
NUMBER OF CORNER R  MAX VALUE OF CORNER R  SUM OF LENGTH AND WIDTH  mm

<BENDING PATTERN>

FOR SURFACE ☐ THREE SUR- ☐ ONE TO TWO SUR- ☐ PARALLEL TWO ☐ L-SHAPE ☐ OUTER CIRCUMFERENCE FLANGE EMBOSING  
☐ BENDING ☐ FACE BENDING ☐ SURFACE BENDING ☐ BENDING ☐ BENDING

MANUFACTURING STEP		INPUT ITEMS				
NAME		BENDING WIDTH	NUMBER OF POINTS TO BE PROCESSED			
BOX-SHAPE BENDING PLUS INTERNAL L-SHAPE BENDING	1	5	1			
	2	0	0			
BEAD	1	0	0			
	2	0	0			
SQUARE-SHAPE (CIRCLE-SHAPE) EMBOSING	1	0	0	OUTER CIRCUMFERENCE LENGTH	EMBOSING DEPTH	NUMBER OF POINTS TO BE PROCESSED
	2	0	0	0	0	0
FLATTENING BY PRESSING (HOLE PORTION)	1	0	0	CIRCUMFERENCE LENGTH	NUMBER OF POINTS TO BE PROCESSED	
	2	0	0	0	0	0



BACK
CANCEL
HELP

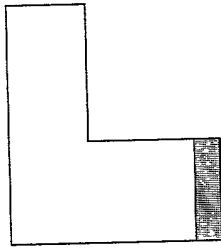
12/20  
FIG.11

MOLD REMODELING INFORMATION  
(FORMING APPEARANCE)

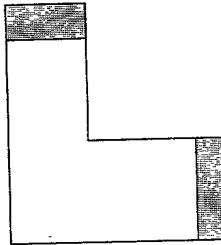
<REMODELING PATTERN>

☒ NO REMODELING

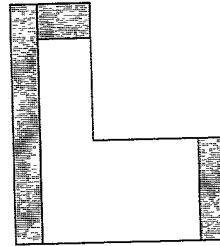
☐ A)



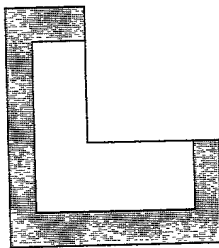
☐ B)



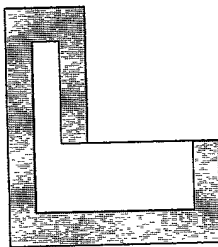
☐ C)



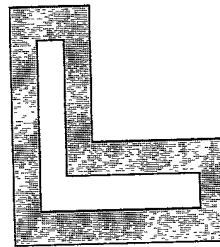
☐ D)



☐ E)



☐ F)



ENLARGING SIZE



REDUCING SIZE

BACK

CANCEL

HELP

FIG. 11

13/20  
FIG.12

MOLD REMODELING INFORMATION (BOX-SHARE  
BENDING/ STAIR-LIKE BENDING

No.	TYPE OF REMODELING	NUMBER OF POINTS TO BE REMODELED
1	[STAIR-LIKE SHAPING] HEIGHTENING BENDING HEIGHT	2

<REMODELING PATTERN>

- ☐ [BOX-SHAP BENDING] CHANGING BENDING HEIGHT  
OR CHANGING BENDING POSITION
- ☒ [STAIR-LIKE BENDING] HEIGHTENING BENDING HEIGHT
- ☐ [STAIR-LIKE BENDING] LOWERING BENDING HEIGHT
- ☐ UNBENDING

2

NEW

UPLOAD

DELETE

FIG. 13

MOLD REMODELING INFORMATION (PUNCHING)

No.	KIND OF HOLE	PUNCHING NUMBER OF POINTS TO BE PUNCHED	TYPE OF REMODELING	DUPLICATION
No.	CIRCULAR HOLE	5.00	NEWLY ADDING HOLE	DUPLICATION
No.	CIRCULAR HOLE	5.00	CHANGING HOLE DIAMETER (LARGE→SMALL)	NON

3.00

1

POINT

NEWLY ADDING HOLE

CHANGING HOLE DIAMETER

CHANGING HOLE POSITION

LARGE→SMALL

HOLES DUPLICATED

NO DUPLICATION

NEW

UPLOAD

DELETE

BACK

CANCEL

HELP

15/20  
FIG.14

PROCESSING COST INFORMATION					
UNIT PRICE OF COMPONENT	<input type="text" value="0.00"/>	YEN →	COMPUTED UNIT PRICE OF COMPONENT	<input type="text" value="0.00"/>	YEN
PROCESSING COST	<input type="text" value="0.00"/>	YEN →	COMPUTED PROCESSING COST	<input type="text" value="0.00"/>	YEN
					BACK
					CANCEL
					COMPUTE
					HELP


KIND OF SURFACE TREATMENT	chNi 	<input type="text" value="0.000"/>	$\mu$ m
	Ni	<input type="text" value="86.100"/>	mm
	Zn	<input type="text" value="0.000"/>	mm
	ChNi		
	....		

FIG. 14

PRESS		MENU	
CODE NUMBER <input style="width: 80%;" type="text"/>	SUFFIX <input style="width: 80%;" type="text"/>	GUIDING PLATE: SHEET DELIVERY: TOP	
KIND <input style="width: 80%;" type="text"/>	NAME OF COMPONENT <input style="width: 80%;" type="text"/>		
UNIT PRICE OF COMPONENT <input style="width: 80%;" type="text"/>	MATERIAL EXPENSE <input style="width: 80%;" type="text"/>	(CHILD COMPONENT COST) <input style="width: 80%;" type="text"/>	0 YEN
	MANUFACTURING COST <input style="width: 80%;" type="text"/>	PRIMARY MANUFACTURING COST <input style="width: 80%;" type="text"/>	10.81 YEN
	OTHERS <input style="width: 80%;" type="text"/>	SECONDARY MANUFACTURING COST <input style="width: 80%;" type="text"/>	0 YEN
(MOLD COST DATA) COMPUTATION OF SUM TOTAL <input style="width: 80%;" type="text"/> YEN <input type="radio"/> NOT USE <input checked="" type="radio"/> TYPICAL MOLD <input type="radio"/> MASTER DIE SET TYPE MOLD			
MONTHLY LOT <input style="width: 80%;" type="text"/>	LOTS/MONTH <input style="width: 80%;" type="text"/>	TOTAL LOT <input style="width: 80%;" type="text"/>	LOTS <input style="width: 80%;" type="text"/>
MATERIAL CODE <input style="width: 80%;" type="text"/>	LIST <input style="width: 80%;" type="text"/>	MATERIAL NAME <input style="width: 80%;" type="text"/>	SPC SE BOARD THICKNESS <input style="width: 80%;" type="text"/> mm
MATERIAL FORM <input style="width: 80%;" type="text"/>	SECURE NUMBER <input style="width: 80%;" type="text"/>	EXTEND WIDTH <input style="width: 80%;" type="text"/> mm	OUTER CIRCUM-FERENCE LENGTH <input style="width: 80%;" type="text"/> mm
EXTEND LENGTH <input style="width: 80%;" type="text"/>			
(MANUFACTURING STEP INFORMATION) <input type="checkbox"/> COMPONENT HARD TO HANDLE			
NO.	NAME OF MANUFACTURING STEP	DESIGNATED COST CENTER	MANUFACTURING COST
1	APPEARANCE FORMING PLUS PUNCHING	PRESS90t	4.85
2	BOX-SHAPE BENDING	PRESS80t	6.76
3	BOX-SHAPE BENDING	PRESS70t	6.76
4	BEAD	PRESS60t	6.49
		MOLD COST	REMODEL
		764.88	
		654.265	
		564.321	
		645.312	
<input type="checkbox"/> COMPONENT HARD TO HANDLE			
READ <input type="button" value="REGISTER"/> <input type="button" value="COMPUTE"/> <input type="button" value="ALL CLEAR"/> <input type="button" value="COMPUTATION RESERVE"/>			

MANUFACTURING STEP INFORMATION

CHILD COMPONENT INFORMATION

PROCESSING COST INFORMATION

COMPUTATION OF MATERIAL HANDLING COST

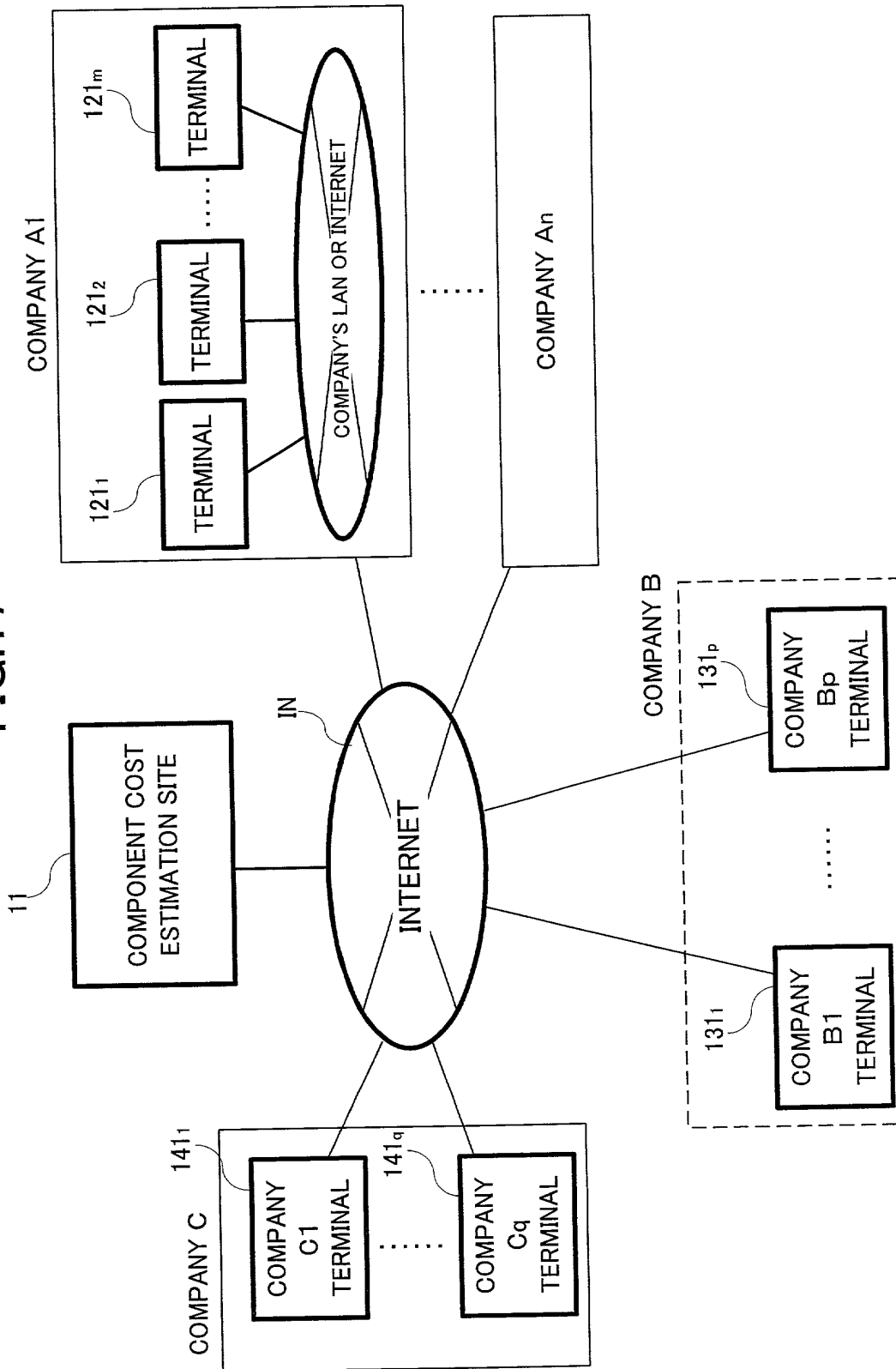
LIST OF COMPONENTS FOR COST COMPUTATION

LIST OF MOLDS FOR COST COMPUTATION

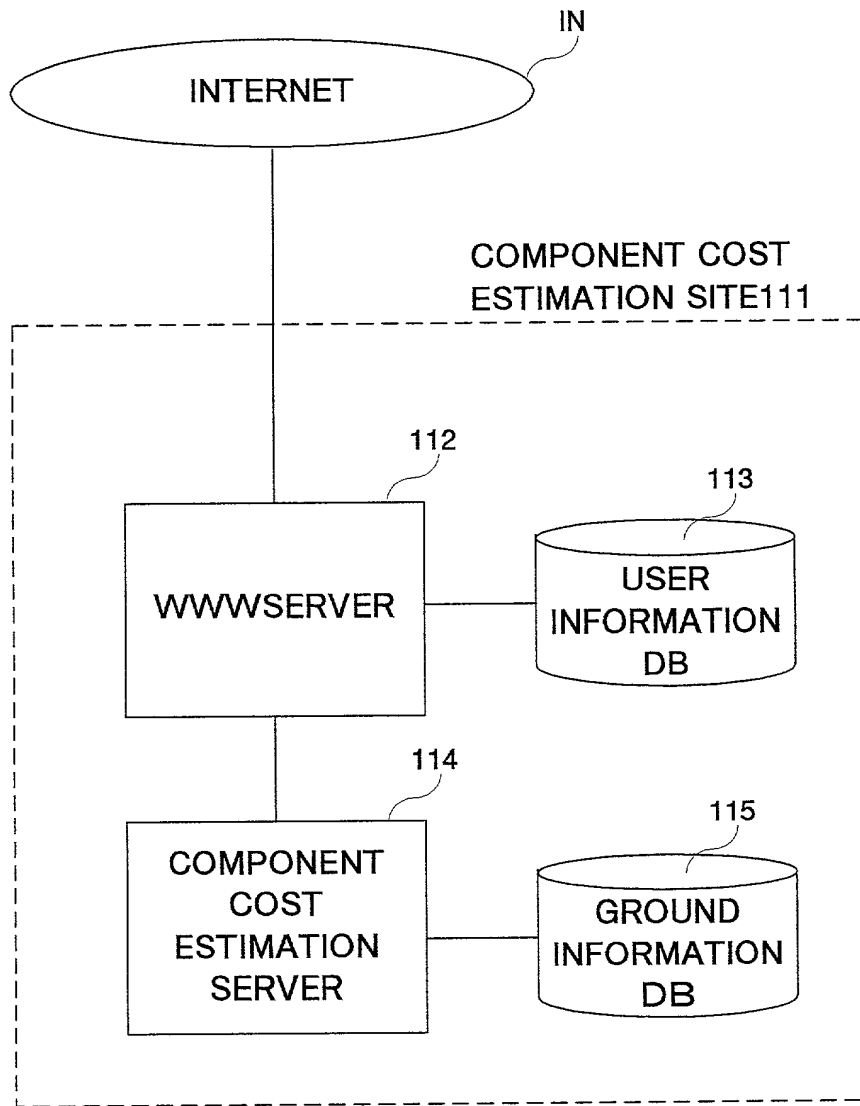


Table 1. Demographic characteristics of the study population	
Age (years)	65.2 ± 1.2
Gender (male/female)	102/108
Education (years)	12.5 ± 0.5
Marital status (married/divorced/widowed)	150/30/20
Occupation (retired/employed)	150/30
Income (USD/month)	1,200 ± 200
Comorbidities (hypertension/diabetes/cholesterol)	80/40/60
Medication (antidepressants/antipsychotics)	120/20
Alcohol consumption (yes/no)	30/170
Smoking status (current/former/never)	20/80/160
Family history (depression/schizophrenia)	40/20
Duration of illness (years)	10.5 ± 2.0
Previous hospitalizations (yes/no)	100/30
Current symptoms (depression/schizophrenia)	150/30
Functional status (independent/dependent)	120/20
Social support (adequate/inadequate)	100/30
Quality of life (SF-36 score)	45.0 ± 10.0
Healthcare utilization (yes/no)	150/30
Insurance status (private/public)	80/70
Geographical location (urban/rural)	100/30
Season of admission (spring/summer/autumn/winter)	40/40/40/40
Referral source (primary care/hospital)	100/30
Consent status (yes/no)	150/30

18/20  
FIG.17



19/20  
FIG.18



20/20

FIG.19

The figure shows a graphical user interface for a login process. It consists of a rectangular window with a title bar at the top right containing three standard window control icons (minimize, maximize, and close). The main area of the window is titled "LOGIN" in a bold, sans-serif font. Below the title, there are two labels: "ID" and "PASSWORD", each followed by a text input field. The "ID" field contains the text "sizai", and the "PASSWORD" field contains the text "password". At the bottom of the window, there are two buttons: "LOGIN" on the left and "CANCEL" on the right, both in a simple rectangular box with text in the center.

LOGIN	
ID	sizai
PASSWORD	password
<div>LOGIN CANCEL</div>	

FIG. 19